

Work Order ID 93264

93264

Page 1

November-15-12 10:41:52 AM

Item ID: D350-567-141

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Floor Window Closeout Installation

Start Date: 11/15/12 Start Qty: 6.00

6

Cust Item ID:

Required Date: 12/07/12 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: M-LJ

Date: 12-11-15 Tooling:

Date:

Run Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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DSI 9590 100 *100* DC Document Control	C DOCUMENT CONTROL Memo Photocopy bluefile & type labels per PPP D350-567-141 CHG002	0.00	DAS 15 12.12.21						OK for m/w 12/12/12
---	---	------	-----------------------	--	--	--	--	--	---------------------

110 *110* Packaging Packaging	Pick Kit Memo	0.00							R1414/19 (E)
---	------------------	------	--	--	--	--	--	--	--------------

120 *120* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00	DAS 15 12.12.21						6
--	---	------	-----------------------	--	--	--	--	--	---

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS						
			Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other				
Part No. _____ NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio		<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <hr/> <hr/> <hr/>	
										<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <hr/> <hr/> <hr/>	
										<input type="checkbox"/> Other	

Work Order ID 93264

93264

Page 2

November-15-12 10:41:52 AM

Item ID: D350-567-141

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Floor Window Closeout Installation

Stop

NS2

Start Date: 11/15/12 Start Qty: 6.00

6

Cust Item ID:

Required Date: 12/07/12 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Packaging

Packaging

0.00

SL 12/12/21

Packaging

Memo
Identify and pack for shipping as per PPP D350-567-141
Location: FC 054A

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Quality Control

Memo

0.00

CK 12/12/21
MF
12-12-21

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Date: ✓

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>				
Part No. _____											
NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
Bending	General			Bend	General			Grain	Ovalized	Pressure/Forced	
Centre Not Concentric to O/S				BOM/Route				Hardware	Over/Under tolerance	Temperature/Cure	
Cracks				Broken/Damaged				Inspection Incomplete	Part Incorrect	Weld	
Crushed/Crimped.				Burrs				Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled	
Cuffs				Contamination				Maintenance	Part Moved		
Heat Treat				Countersink				Mislabeled	Positioned Wrong		
Inspection Strip in Tube				Cut Too Short				Misread	Power Loss/Surge		
Ripples in Bend				Drill Holes				Offset			
Torque Waves in Extrusion				Drawing				Out of Calibration			
Turning Sequence				Finish				Out of Sequence			
Wave/Twist in Tube				Folio				Outside Dimensions			

Picklist Print

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Page 1

Work Order ID: 93264

Parent Item: D350-567-141

Start Date: 11/15/12

Required Date: 12/07/12

Parent Item Name: Floor Window Closeout Installation

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 11.11.09 new issue DD verf:JLM
ECN12-511 DD VERF:EC IPP REV:C 12.03.05 AS PER
IPP REV:B 12.01.23 AS PER ECN12-537 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3802-1 Window Seal		Manufactured	No			110	f	407.1400	2	12	1		

24" 024

6x24" Sm 6X

Location	Loc Qty	Loc Code
ST408	407.14	
56881	0.75	
81021	2	
81868	404.39	

81868

D4434-041

Fwd Bracket Assembly

Sm 6X

Location	Loc Qty	Loc Code
ST272	4	
85859	4	
ST274	1	
83538	1	

6 93376

D4434-047

Cover Assembly

Sm 6X

Location	Loc Qty	Loc Code
ST273	2	
85839	2	

936318

D4435-045

T/R Bellcrank Cover Assembly

Sm 6X

Location	Loc Qty	Loc Code
ST273	1	
83535	1	

6 93214

D4435-91
Bracket

D4436-041

Aft Bracket Assembly

Sm 6X

Location	Loc Qty	Loc Code
ST273	1	
83535	1	

12- B93342

Sm 6X

Location	Loc Qty	Loc Code
ST273	1	
83535	1	

6

93215

NCR: Yes / No

WORK ORDER NON-COMPLIANCE / UPDATE

DQA: Date: ✓

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>				
Part No. _____											
NCR No. _____											
Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear	General										
	Bending	<input type="checkbox"/>	Grain	<input type="checkbox"/>	Ovalized	<input type="checkbox"/>	Pressure/Forced				
	Centre Not Concentric to O/S	<input type="checkbox"/>	Hardware	<input type="checkbox"/>	Over/Under tolerance	<input type="checkbox"/>	Temperature/Cure				
	Cracks	<input type="checkbox"/>	Inspection Incomplete	<input type="checkbox"/>	Part Incorrect	<input type="checkbox"/>	Weld				
	Crushed/Crimped.	<input type="checkbox"/>	Instructions Incomplete/Unclear	<input type="checkbox"/>	Part Lost/Missing	<input type="checkbox"/>	Wrong Stock Pulled				
	Cuffs	<input type="checkbox"/>	Maintenance	<input type="checkbox"/>	Part Moved	<input type="checkbox"/>					
	Heat Treat	<input type="checkbox"/>	Mislabeled	<input type="checkbox"/>	Positioned Wrong	<input type="checkbox"/>					
	Inspection Strip in Tube	<input type="checkbox"/>	Misread	<input type="checkbox"/>	Power Loss/Surge	<input type="checkbox"/>					
	Ripples in Bend	<input type="checkbox"/>	Offset	<input type="checkbox"/>	Other	<input type="checkbox"/>					
	Torque Waves in Extrusion	<input type="checkbox"/>	Out of Calibration	<input type="checkbox"/>		<input type="checkbox"/>					
	Turning Sequence	<input type="checkbox"/>	Out of Sequence	<input type="checkbox"/>		<input type="checkbox"/>					
	Wave/Twist in Tube	<input type="checkbox"/>	Outside Dimensions	<input type="checkbox"/>		<input type="checkbox"/>					

Picklist Print

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Page 2

Work Order ID: 93264

Parent Item: D350-567-141

Parent Item Name: Floor Window Closeout Installation

Start Date: 11/15/12

Required Date: 12/07/12

Start Qty: 6.00

Required Qty: 6.00

D4441-1

Rubber Seal

24

1-270

Smf

Manufactured No

110 f 651.1146

12

Location

Loc Qty

Loc Code

ST412

651.1146

74760

6.119

79385

0.0476

80763

159.54

86185

485.408

AN3-3A

Bolt

Smf (X)

Purchased No

110 Each 286.0000

42

Location

Loc Qty

Loc Code

ST350

286

122800

186

123352

100

AN525-832R7

Screw

Smf (X)

Purchased No

110 Each 434.0000

12

Location

Loc Qty

Loc Code

ST345

434

120519

34

120560

400

MS21042L06

Nut

Smf (X)

Purchased No

110 Each 331.0000

42

Location

Loc Qty

Loc Code

315

258

122441

258

ST317

73

122151

73

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS						
			Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other				
Part No. _____ NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio		<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <hr/> <hr/> <hr/>	
										<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled	
										<input type="checkbox"/> Other	

Picklist Print

November-15-12 10:41:51 AM

Page 3

Work Order ID: 93264

Parent Item: D350-567-141

Parent Item Name: Floor Window Closeout Installation

Start Date: 11/15/12

Required Date: 12/07/12

Start Qty: 6.00

Required Qty: 6.00

MS21042L08

Nut

Purchased

No

110

Each

860.0000



12

Smp (X)

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

315	9	
122452	9	
ST315	500	
122814	500	
ST317	351	
122141	351	

MS21042L13

Nut

Purchased

No

110

Each

2,276.0000



30

3m (X)

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

316	541	
122452	541	
ST300	225	
117885	32	
119017	55	
119075	138	
ST314	1189	
123265	1189	
ST317	321	
122141	321	

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
NCR No. _____	Use-as-is <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>					
	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Composite <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>					
	Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Supplier <input type="checkbox"/>							
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data										
Equip/Tooling										
Operator										
Material										
Setup										
Other										
Process										
Supplier										
Training										
Unapproved										
FAULT CATEGORY										
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions						
				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Other						

Picklist Print

November-15-12 10:41:51 AM

Page 4

Work Order ID: 93264

Parent Item: D350-567-141

Parent Item Name: Floor Window Closeout Installation

Start Date: 11/15/12

Required Date: 12/07/12

Start Qty: 6.00

Required Qty: 6.00

MS21059L3

Purchased

No

110

Each

217.0000



12

Nut Plate

6X

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
302	10	
	121185	
ST301	28	
	118614	
	119546	
ST302	20	
	120308	
	120833	
	121444	121444
	121524	
ST316	120	
	59	
	122814	
	59	

MS35206-229

Screw

SmB 6X

Purchased

No

110

Each

65.0000



42

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST293	65	
	121039	

NAS1149F0332P

WASHER

SmB 6X

Purchased

No

110

Each

1,138.0000



72

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
275	162	
	122441	
ST275	776	
	117735	
	119225	
	121259	
	121825	
	122063	
	17317	
ST295	138	
	200	
	123352	
	200	

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-COMPLIANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>				
Part No. _____											
NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
Bending				Bend <input type="checkbox"/>	Grain <input type="checkbox"/>	Ovalized <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>				
Centre Not Concentric to O/S				BOM/Route <input type="checkbox"/>	Hardware <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>				
Cracks				Broken/Damaged <input type="checkbox"/>	Inspection Incomplete <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Weld <input type="checkbox"/>				
Crushed/Crimped.				Burrs <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>				
Cuffs				Contamination <input type="checkbox"/>	Maintenance <input type="checkbox"/>	Part Moved <input type="checkbox"/>					
Heat Treat				Countersink <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>					
Inspection Strip in Tube				Cut Too Short <input type="checkbox"/>	Misread <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	Other <input type="checkbox"/>				
Ripples in Bend				Drill Holes <input type="checkbox"/>	Offset <input type="checkbox"/>						
Torque Waves in Extrusion				Drawing <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>						
Turning Sequence				Finish <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>						
Wave/Twist in Tube				Folio <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>						

Picklist Print

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Page 5

Work Order ID: 93264

Parent Item: D350-567-141

Parent Item Name: Floor Window Closeout Installation

Start Date: 11/15/12

Required Date: 12/07/12

Start Qty: 6.00

Required Qty: 6.00

NAS1149EN616P

WASHER

Purchased No

110 Each 641.0000

114

84

Smt 6Y

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST275	641	
117317	15	
120560	626	

NAS1149EN816P

WASHER

Purchased No

Each 725.0000

120560

12

Smt 6Y

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST275	725	
117316	215	
121039	510	

121439

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS								
Part No. _____	Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>							
NCR No. _____	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>								
	Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>								
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector				
Doc/Data													
Equip/Tooling													
Operator													
Material													
Setup													
Other													
Process													
Supplier													
Training													
Unapproved													
FAULT CATEGORY													
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions						<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Other			

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-567 REV. D OR EARLIER
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-567 REV. 1 OR EARLIER
REF CANADIAN STC: SH92-18
FAA STC: SH989NE
FAA STC: SH990NE

1.0 Purpose

The purpose of this service instruction is to add the D350-567-141 Close-out Kit, which is intended for customers wishing to operate their aircraft with the interior floor window removed. The D350-567-141 Floor Window Close-out Kit provides a barrier around the interior and exterior vertical reference floor window to prevent objects from falling into the aircraft controls when the interior floor window is removed as shown in Figure 1.

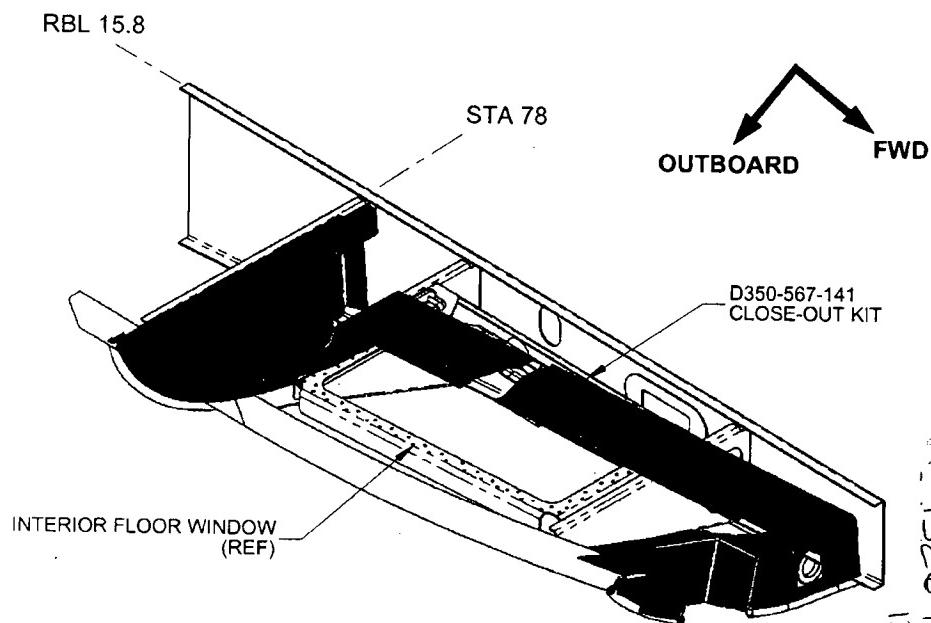


Figure 1. Floor Window Close-out Kit Installation

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED <i>[Signature]</i>	
BY:	D. SHEPHERD (DE # 02)
DATE:	12.03.13
CERT. NO.:	SH92-18
ISSUE NO.:	6

C	DESCRIPTION	RF	DATE
D	CORRECT TYPO NAS1149FN816P WAS NAS1149FN882P	RF	12.03.13
B	MS35206-229 WAS AN525-632R6; NAS1149FN616P (Qty 14) WAS (Qty 9); MS21042L06 (Qty 7) WAS (Qty 9); ADD AN525- 832R7, NAS1149FN882P & MS21042L08	RF	12.02.22
A	NEW ISSUE	RF	12.01.09
REV.		BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	N/A	DSI 9590	SHEET 1 OF 12
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FLOOR WINDOW CLOSE-OUT KIT NTS	
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2.0 Part List

Qty -141	Part Number	Description
X	D350-567-141	FLOOR WINDOW CLOSE-OUT KIT
1	D3802-1-024	SEAL (24")
1	D4434-041	FWD BRACKET ASSEMBLY
1	D4434-047	COVER ASSEMBLY
1	D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	D4435-9	BRACKET
1	D4436-041	AFT BRACKET ASSEMBLY
1	D4441-1-240	RUBBER SEAL (24")
7	AN3-3A	BOLT
2	AN525-832R7	SCREW
7	MS21042L06	NUT (OR MS21042-06)
2	MS21042L08	NUT (OR MS21042-08)
5	MS21042L3	NUT (OR MS21042-3)
2	MS21059L3	NUTPLATE
7	MS35206-229	SCREW
12	NAS1149F0332P	WASHER (AN960-10L)
14	NAS1149FN616P	WASHER (OR AN960-6L)
2	NAS1149FN816P	WASHER (OR AN960-8L)

3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141 Kit.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141 Floor Window Close-out Kit	3.9 lb 1.77 kg	17.9 in 0.45 m	69.8 in-lb 0.80 m-kg	65.5 in 1.66 m	255.5 in-lb 2.94 m-kg

4.0 Installation Procedure

Notes:

- 1) Figure 2 shows the general arrangement and installation of the D350-567-141 Close-out Kit. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- 2) In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
 - D350-567-115 — OK to remove D3295-041
 - D350-567-031 — OK to remove D3212-1
 - D350-567-011 — OK to remove D2214
 - D350-567-021 — OK to remove D2951
- 3) It is acceptable to drill/trim the D350-567-141 Close-out Kit as required to improve fit.

CANADA
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AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA <small>DRAWING NO.</small> DSI 9590 <small>REV. C</small> <small>SHEET 2 OF 12</small>
DRAWN	RF	
CHECKED	<i>[Signature]</i>	
MFG. APPR.	N/A	
APPROVED	<i>[Signature]</i>	
DE APPR.	<i>[Signature]</i>	
DATE 12.03.13		SCALE
FLOOR WINDOW CLOSE-OUT KIT		
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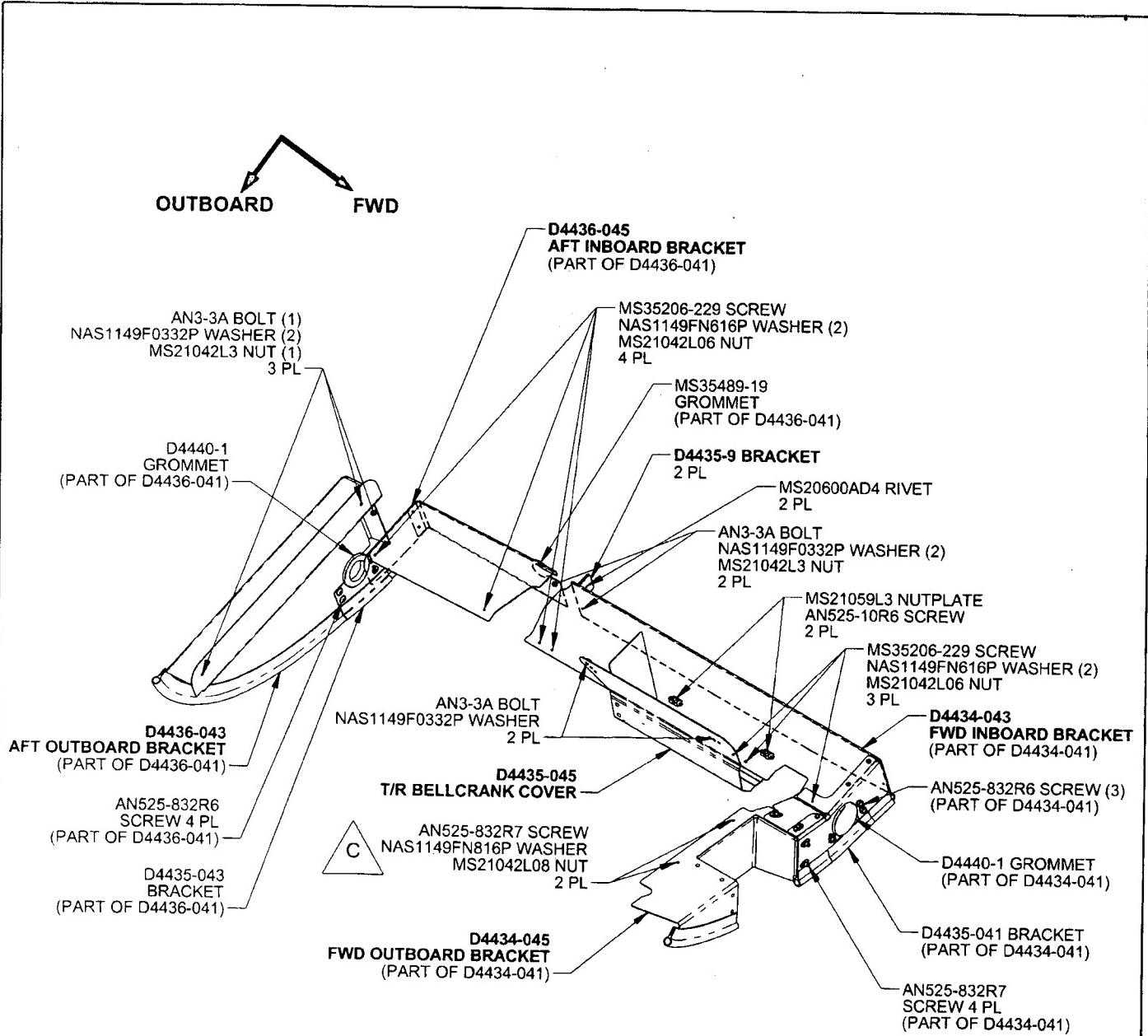


Figure 2. Floor Window Close-out Kit Installation

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CERT. NO.:	SH92-18
ISSUE NO.:	6

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CHECKED	<i>[Signature]</i>	DRAWING NO. DSI 9590
MFG. APPR.	N/A	
APPROVED	<i>[Signature]</i>	REV. C SHEET 3 OF 12
DE APPR.	<i>[Signature]</i>	
DATE	12.03.13	TITLE FLOOR WINDOW CLOSE-OUT KIT
		SCALE NTS
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- 4.1 Temporarily install D4436-043 Aft Outboard Bracket and D4436-045 Aft Inboard Bracket using clecos and/or clecos clamps. Before drilling holes:
- Position the D4436-043 Aft Outboard Bracket so the flange contacts the main beam as shown in Figure 3.
 - Confirm that the D4436-043 Aft Outboard Bracket and beam angle are parallel as shown in Figure 4.
- 4.2 Temporarily install D4434-043 Fwd Inboard Bracket and D4434-045 Fwd Outboard Bracket using clecos and cleco clamps. Confirm there is no contact between D4436-045 Aft Inboard Bracket and D4434-043 Fwd Inboard Bracket and main beam gusset as shown in Figure 5.
- 4.3 If aircraft is equipped with Collective Circuit Breaker Board box trim D4434-043 Fwd Inboard Bracket as shown in Figure 14. Install D4434-047 Cover as shown in Figure 13. Note: Confirm the D4434-047 Cover fits over the Collective Circuit Breaker Board box. Adjust opening as required.
- 4.4 Drill off rivets holding plastic wire bundle stand offs. Transfer drill \varnothing 0.144 holes to D4436-045 Aft Inboard Bracket per Figure 6. Transfer drill 2 x \varnothing 0.144 holes to D4434-043 Fwd Inboard Bracket per Figure 7. Transfer drill 2 x \varnothing 0.144 holes for D4434-043 Fwd Inboard Bracket per Figure 8. Before drilling confirm the D4434-043 and D4436-045 brackets are flush with outboard edge of main beam flange. Assemble D4436-045 Aft Inboard Bracket and D4434-043 Fwd Inboard Bracket and wire bundle stand offs to main beam flange using MS35206-229 screw, NAS1149FN616P washer and MS21042L06 nut.
- 4.5 Install D4436-043 Aft Outboard Bracket using AN3-3A bolt and NAS1149F0332P washer and MS21042L3 nut per Figure 9.
- 4.6 Remove 2 rivets holding RH heating plastic stand off as shown in Figure 10. Position the D4435-9 Brackets on the in/outboard sides of the cross beam and transfer drill 2 x \varnothing 0.129 holes from crossbeam to both D4435-9 Brackets. Install D4435-9 Brackets and RH heating plastic stand off using MS20600AD4 rivets or equivalent.
- 4.7 Drill a pilot hole from D4435-9 Bracket to the D4434-045 Fwd Inboard Bracket and D4436-045 Aft Inboard Bracket and open to \varnothing 0.191. Install AN3-3A bolt, NAS1149F0332P washer and MS21042L3 nut as shown in Figure 10. Be sure to maintain edge distance.
- 4.8 Transfer drill 2 x \varnothing 0.144 holes from crossbeam to D4434-045 Fwd Outboard Bracket if holes exist in crossbeam. If holes do not exist, drill 2 x \varnothing 0.144 holes at either end of D4434-045 bracket as shown in Figure 11. Install AN525-832R7 Screws, NAS1149FN816P washer and MS21042L08 nuts.
- 4.9 Align D4435-045 T/R Bellcrank Cover with existing holes in RH seat track lower frame and temporarily install using clecos and/or cleco clamps as shown in Figure 12.
- 4.10 Transfer drill 2 x \varnothing 0.098 holes from D4435-045 T/R Bellcrank Cover to D4434-043 Fwd Inboard Bracket. Open holes to \varnothing 0.191 and install MS21059L3 nut plate into D4434-043 Fwd Inboard Bracket as shown in Figure 12 and Figure 13. Install D4435-045 T/R Bellcrank Cover using AN525-10R6 screw, AN3-3A bolt and NAS1149F0332P washer per Figure 12 and Figure 13.
- 4.11 The D4440-1 grommets are provided to facilitate the routing of wiring harness thru the close-out kit as required. The wiring harness should be secure to the aircraft structure per AC 43.13.13-1B or AS350 Chapter 20.02.01.
- 4.12 Use the D3802-1-024 Seal to fill gaps between the brackets and the cowlings that are larger than 0.25 inch.
- 4.13 Perform travel/interference check of the flight controls to ensure there is no interference and all controls still have full travel.
- 4.14 Ensure there is a gap between the components of the D350-567-141 Close-out Kit and the aircraft structure so that the Close-out Kit does not chafe, interfere, or cause damage to the surrounding aircraft structure. In areas where the D350-567-041 Close-out Kit may contact the aircraft structure, protect from abrasion using chafing tape or a layer Proseal 890 or MIL-S-8802 class B2 sealant or equivalent as required.



CANADA	
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AIRCRAFT CERTIFICATION	
BRANCH	
DAO # 01-O-01	
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BY:	
D. SHEPHERD (DE # 02)	
DATE:	12.03.13
CERT. NO.:	SH92-18
ISSUE NO.:	6

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED		DRAWING NO. DSI 9590
MFG. APPR.	N/A	
APPROVED		REV. C SHEET 4 OF 12
DE APPR.		
DATE	12.03.13	TITLE FLOOR WINDOW CLOSE-OUT KIT
SCALE NTS		
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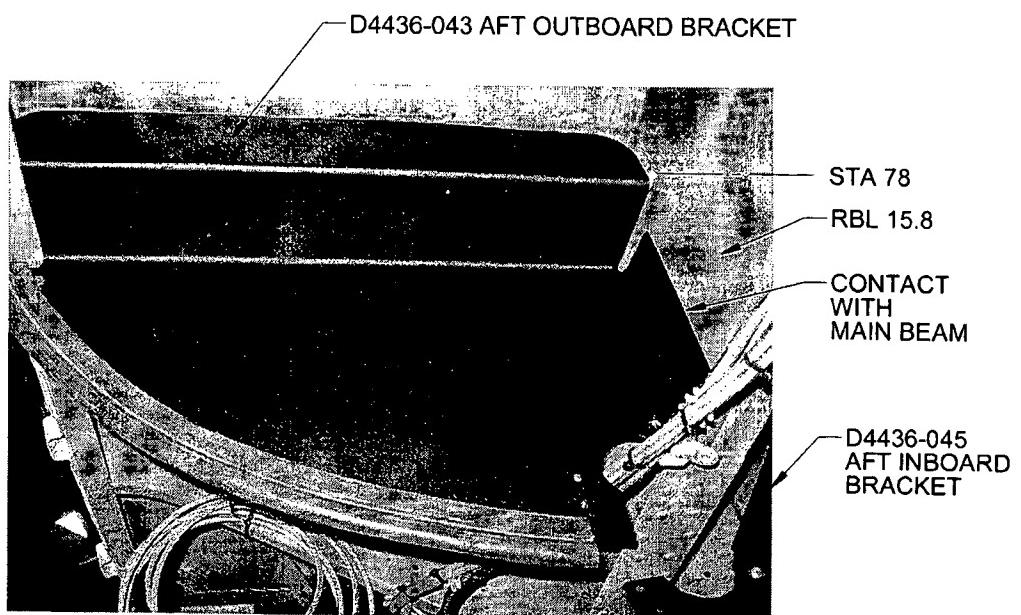


Figure 3. D4436-043 Aft Outboard Bracket Installation

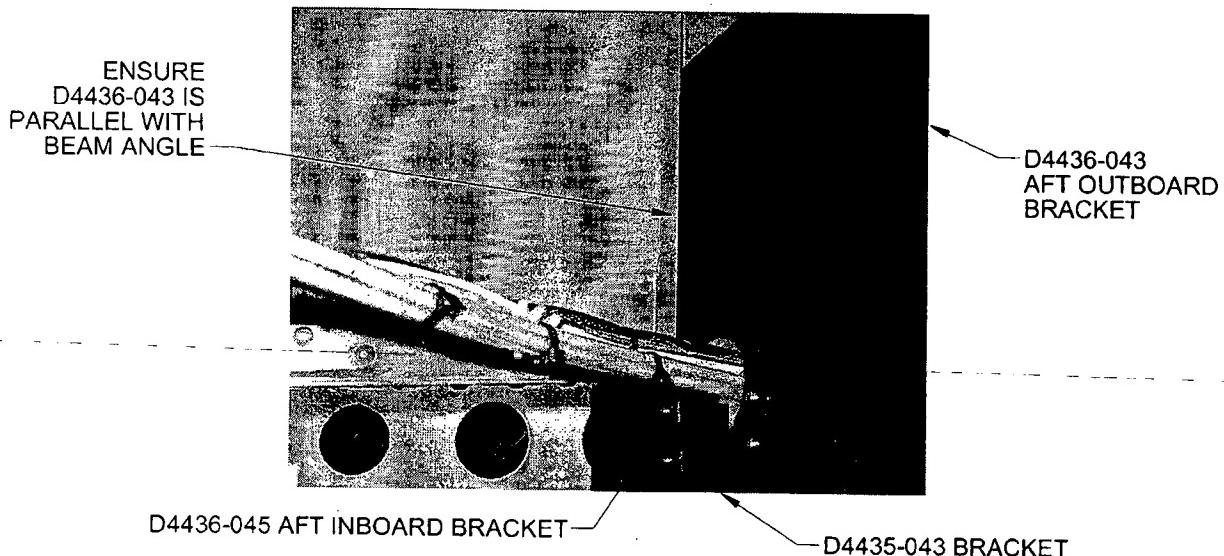


Figure 4. D4436-043 & D4435-043 Brackets Installation

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MFG. APPR.	N/A	
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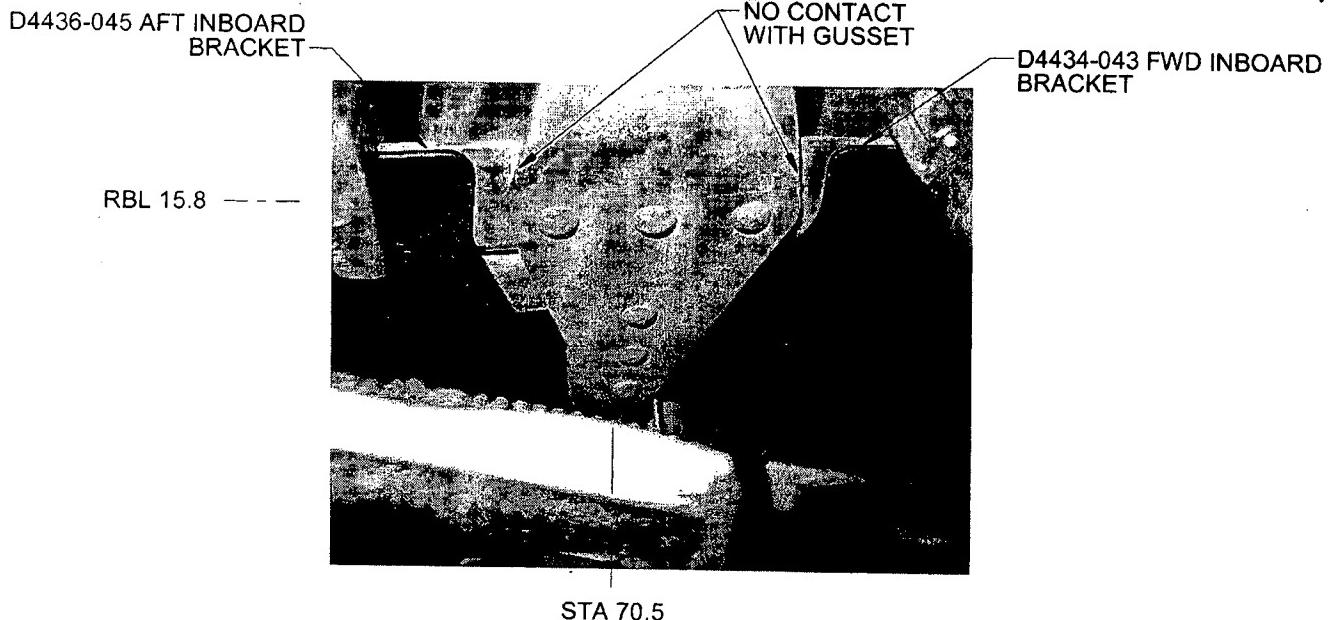


Figure 5. D4436-045 & D4434-043 Brackets Installation

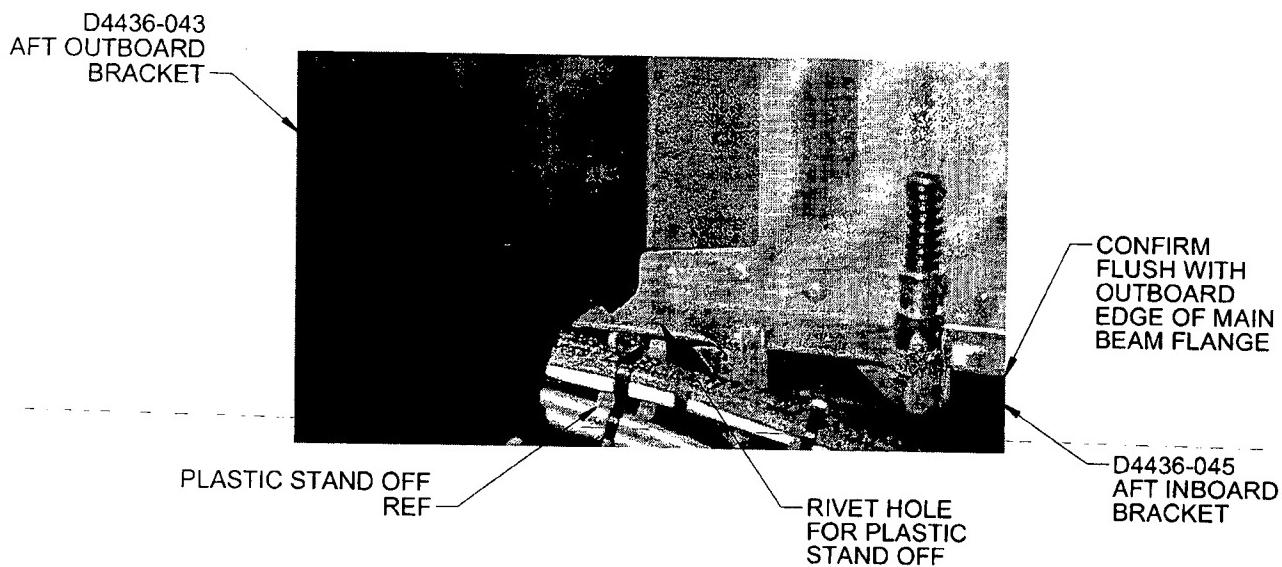


Figure 6. D4436-043 & D4436-045 Brackets Installation

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DAO # 01-O-01

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MFG. APPR.	N/A	DSI 9590	SHEET 6 OF 12		
APPROVED	<i>[Signature]</i>	TITLE			
DE APPR.	<i>[Signature]</i>	SCALE			
DATE	12.03.13	FLOOR WINDOW CLOSE-OUT KIT			
NTS					
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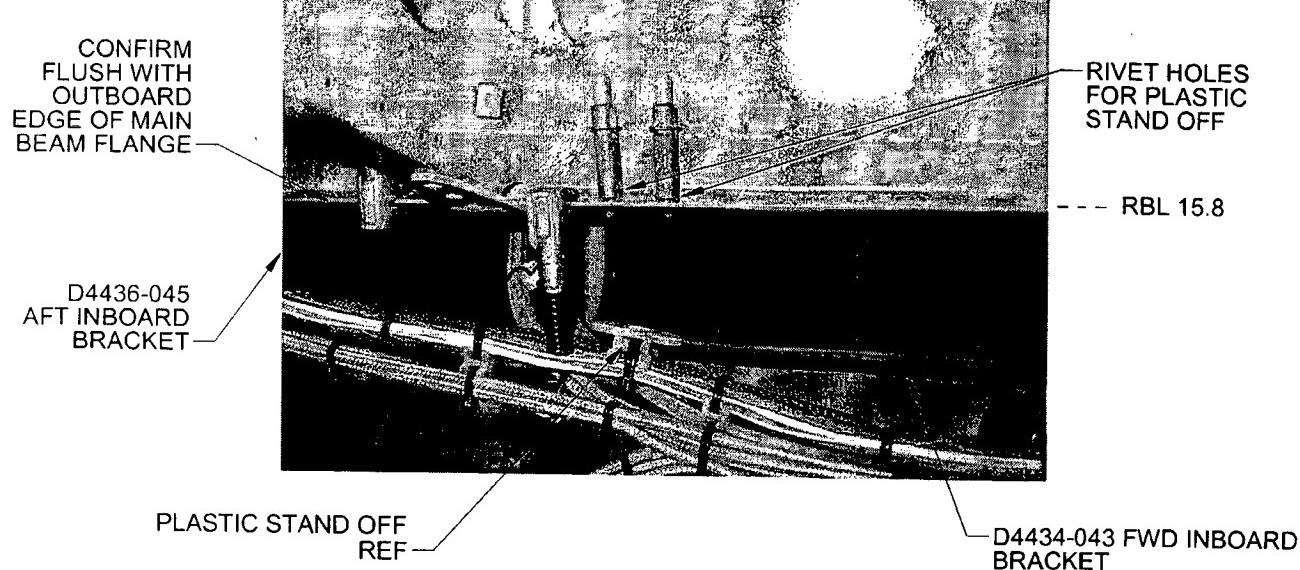


Figure 7. D4434-043 & D4436-045 Brackets Installation

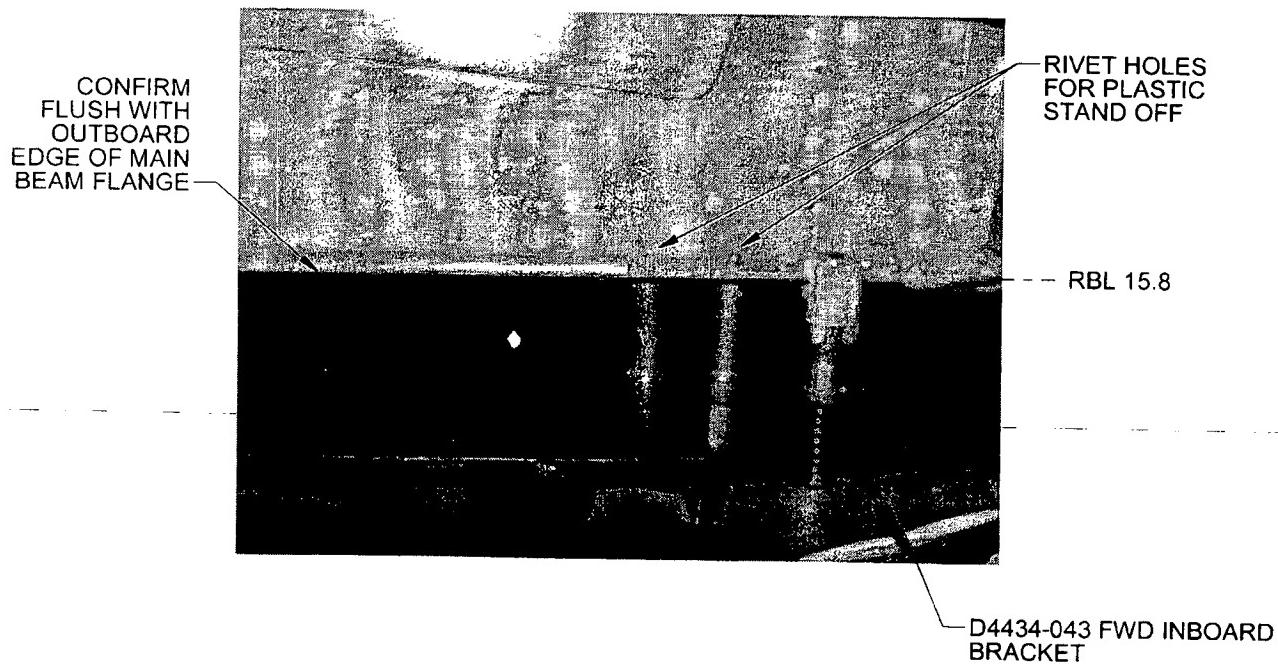


Figure 8. D4434-043 Fwd Inboard Bracket Installation

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DRAWN	RF	
CHECKED	<i>[Signature]</i>	
MFG. APPR.	N/A	
APPROVED	<i>[Signature]</i>	
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INSTALL
 D4436-043
 AFT OUTBOARD BRACKET
 USING
 AN3-3A BOLT (1)
 NAS1149F0332P WASHER (2)
 MS21042L3 NUT (1)

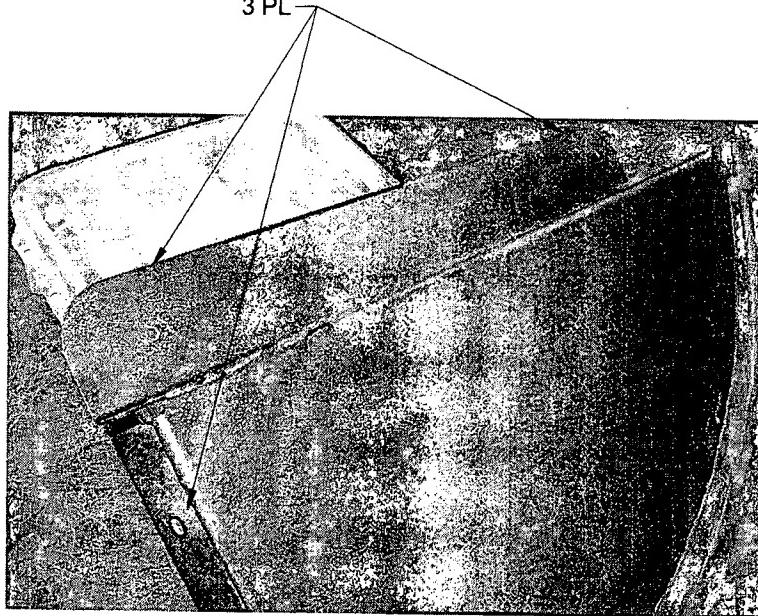
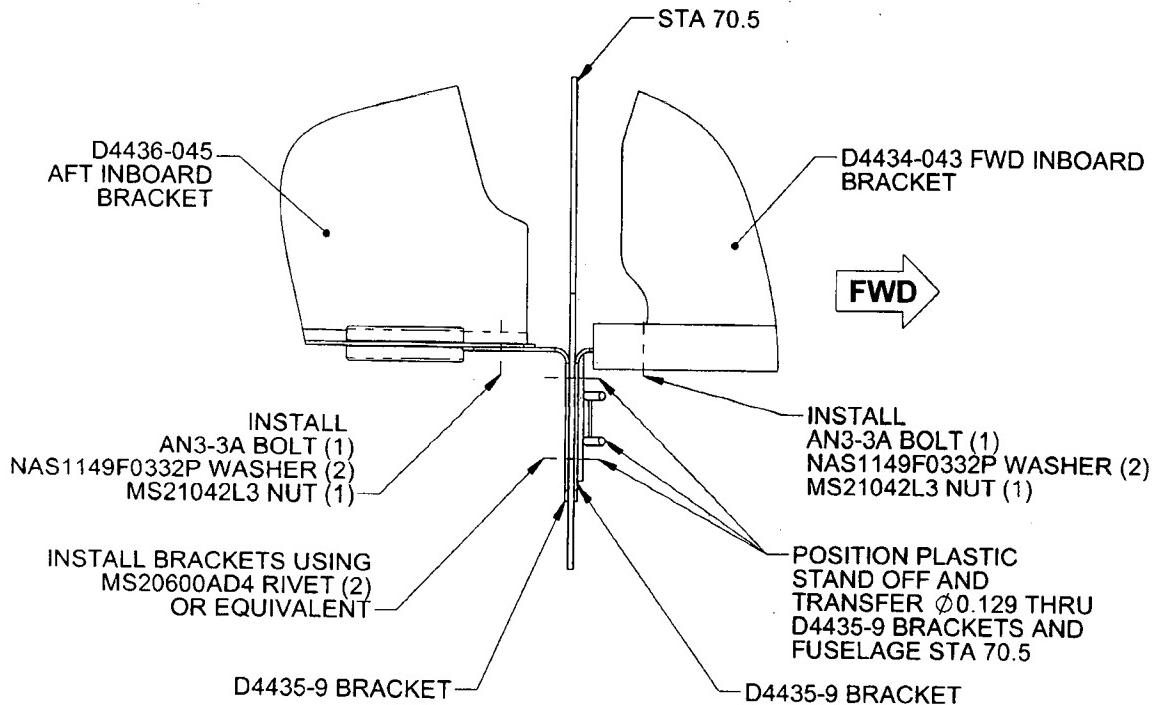


Figure 9. D4436-043 Aft Outboard Bracket Installation

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MFG. APPR.	N/A	DSI 9590
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DE APPR.		SHEET 8 OF 12
DATE	12.03.13	TITLE
		SCALE
		FLOOR WINDOW CLOSE-OUT KIT
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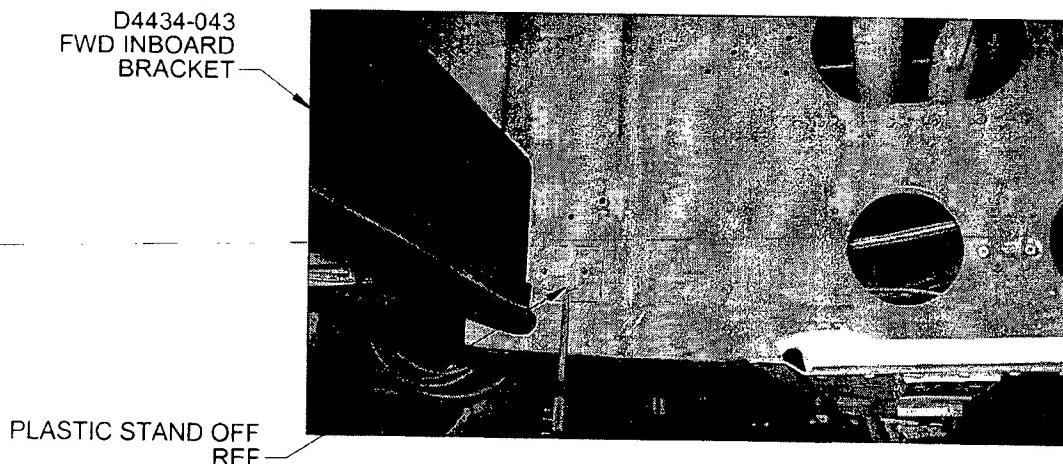


Figure 10. D4434-043 and D4435-9 Brackets Installation

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MFG. APPR.	N/A	DSI 9590	SHEET 9 OF 12
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DE APPR.	<i>[Signature]</i>	FLOOR WINDOW CLOSE-OUT KIT	
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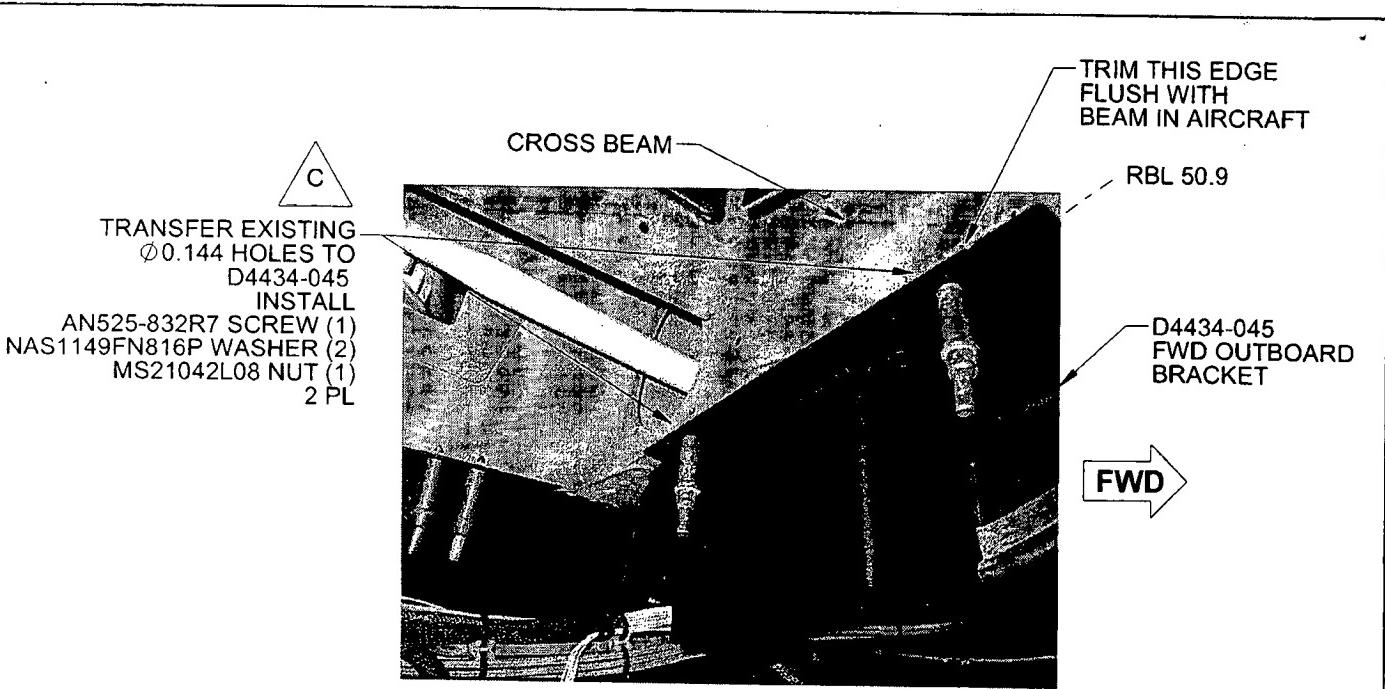


Figure 11. D4434-045 Bracket Installation

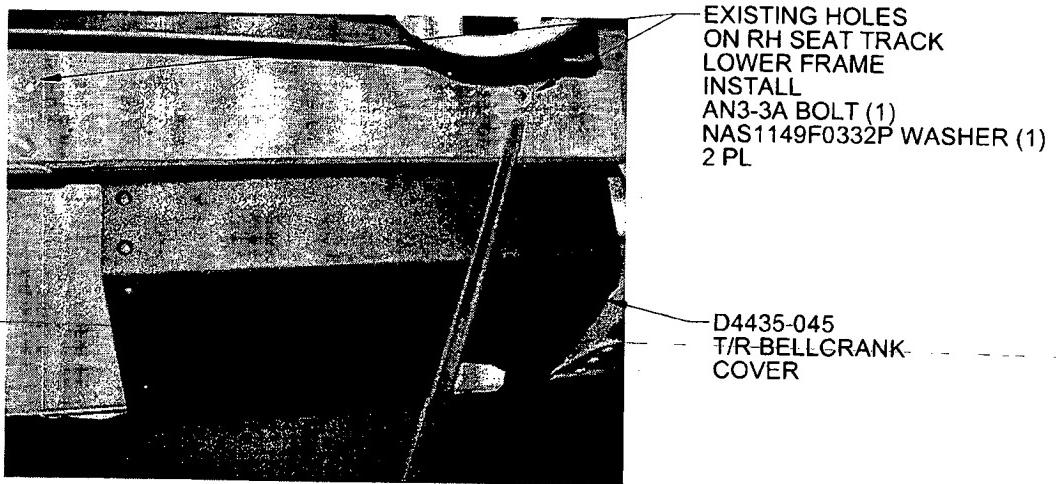


Figure 12. D4435-045 T/R Bellcrank Cover Installation

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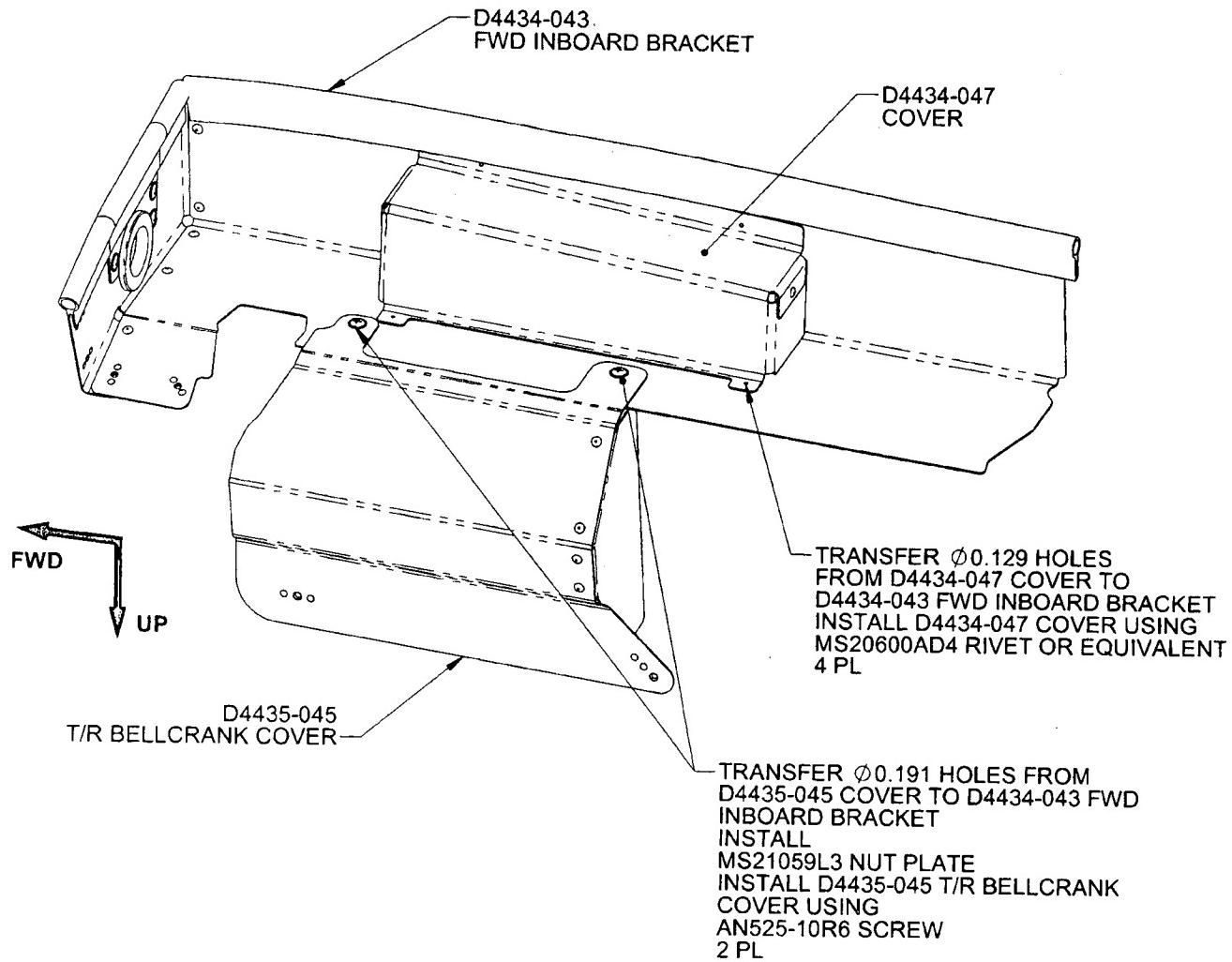


Figure 13. D4435-045 & D4434-047 Cover Installation

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BRANCH
DAO # 01-O-01

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CHECKED	<i>[Signature]</i>	DRAWING NO. DSI 9590
MFG. APPR.	N/A	REV. C
APPROVED	<i>[Signature]</i>	SHEET 11 OF 12
DE APPR.	<i>[Signature]</i>	SCALE
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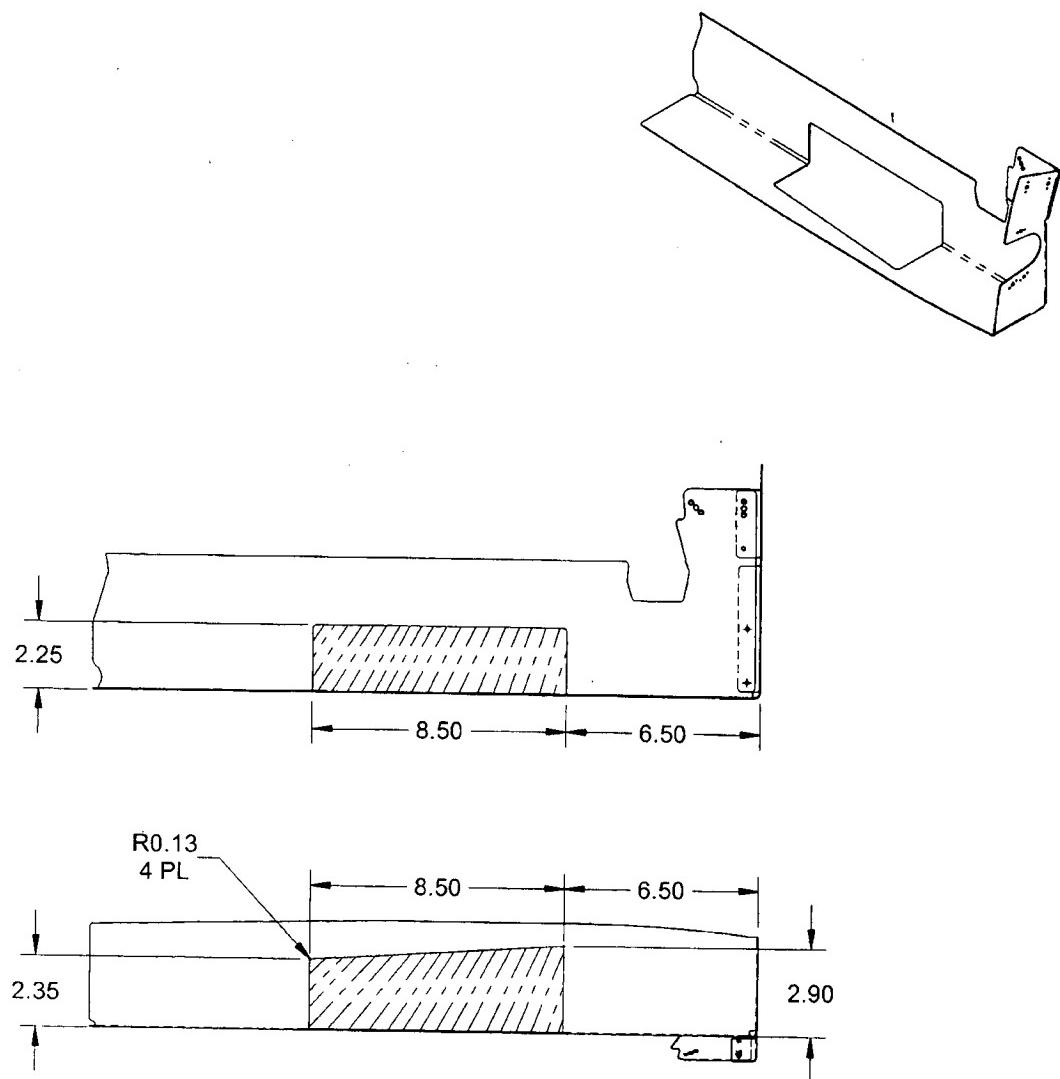


Figure 14. D4434-043 Fwd Inboard Bracket Cutout

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	N/A	DSI 9590	SHEET 12 OF 12
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FLOOR WINDOW CLOSE-OUT KIT NTS	
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REFERENCE ONLY

SM3

2.0 Part List

Qty -141	Part Number	Description
X	D350-567-141	FLOOR WINDOW CLOSE-OUT KIT
1	D3802-1-024	SEAL (24")
1	D4434-041	FWD BRACKET ASSEMBLY
1	D4434-047	COVER ASSEMBLY
1	D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	D4435-9	BRACKET
1	D4436-041	AFT BRACKET ASSEMBLY
1	D4441-1-240	RUBBER SEAL (24")
7	AN3-3A	BOLT
2	AN525-832R7	SCREW
7	MS21042L06	NUT (OR MS21042-06)
2	MS21042L08	NUT (OR MS21042-08)
5	MS21042L3	NUT (OR MS21042-3)
2	MS21059L3	NUT PLATE
7	MS35206-229	SCREW
12	NAS1149F0332P	WASHER (OR AN960-10L)
14	NAS1149FN616P	WASHER (OR AN960-6L)
2	NAS1149FN816P	WASHER (OR AN960-8L)



3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141 Kit.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141 Floor Window Close-out Kit	3.9 lb 1.77 kg	17.9 in 0.45 m	69.8 in-lb 0.80 m-kg	65.5 in 1.66 m	255.5 in-lb 2.94 m-kg

4.0 Installation Procedure

Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141 Close-out Kit. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
D350-567-115 — OK to remove D3295-041
D350-567-031 — OK to remove D3212-1
D350-567-011 — OK to remove D2214
D350-567-021 — OK to remove D2951
- It is acceptable to drill/trim the D350-567-141 Close-out Kit as required to improve fit.

CANADA	
DEPARTMENT OF TRANSPORT	
AIRCRAFT CERTIFICATION	
BRANCH	
DAO # 01-O-01	
APPROVED	
BY:	
D. SHEPHERD (DE # 02)	
DATE:	12.03.13
CERT. NO.:	SH92-18
ISSUE NO.:	6

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED		
MFG. APPR.	N/A	
APPROVED		
DE APPR.		
DATE	12.03.13	TITLE SCALE FLOOR WINDOW CLOSE-OUT KIT NTS
DRAWING NO. DS1 9590 REV. C SHEET 2 OF 12		
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